

Date: Thursday, 24/07/2008 2:37:14 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 03.250 SUPPORT		
Job Number	: 40753		Part Number	: D29401		
Estimate Number	: 10387		Drawing Number	: D2940 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 24/07/2008 S.O. No. :		Drawing Revision	: B		
Prsh Rev.	: NC		Material	:		
First Issue	: / / Type : MACHINED PARTS		Due Date	: 04/08/2008 Qty: 20 Um: Each		
Previous Run	: 39685					
Written By	:					
Checked & Approved By	: <u>DUO 08.7.24</u>					
Comment	: Est. C 02.11.26 Rerformat; Added P/O KJ Est Rev:D Added priming as per Rev B 07-04-30 JLM est E 08.03.19 Re-format Ec verified by DD					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DSK081	D2940-1 TURNING DETAIL
		Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s) D2940-1 TURNING DETAIL Batch: <u>B40801</u> H.A 08/08/16
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS 1- Machine as per Folio FA079 2- Tumble & Deburr 8/08/16 H.A 08/08/16
3.0	QC1	INSPECT ALL DIM TO DIM SHEET
		Comment: INSPECT ALL DIM TO DIM SHEET H.A 08/08/16
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK 31 08/08/25
5.0	POWDER COATING	POWDER COATING <u>M108523</u> (20x) 08/08/25
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 *****Mask Inside Surface as per Dwg D2940***** START TIME: <u>10-15</u> OVEN TEMPERATURE: <u>400°</u> FINISH TIME: <u>10-45</u> M 1 08/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 24/07/2008 2:37:14 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 40753

Part Number: D29401

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	SPRAY PAINTING	SPRAY PAINTING
<p>Comment: SPRAY PAINTING</p> <p>Prime inside surface as per Dwg D2940 and QSI 005 4.3.</p> <p>M 08 08 26 20</p>		
<p>7.0 QC3</p> <p>INSPECT POWDER COAT/CHEMICAL CONVERSION</p> <p>M 08 08 26 20</p>		
8.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1</p> <p>Identify and Stock</p> <p>Location: LG</p> <p>M 08 08 28 20</p>		
9.0	QC21	FINAL INSPECTION/W/O RELEASE
<p>Comment: FINAL INSPECTION/W/O RELEASE</p> <p>M 08 08 28 20</p>		

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40153
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.153	0.153	0.156	0.156	0.154
AD	3.510	3.530		3.512	3.510	3.514	3.520	3.517
AE	1.633	1.673		1.650	1.647	1.654	1.652	1.652
AF	1.493	1.513		1.499	1.499	1.500	1.500	1.497
AG	0.040	0.060		.056	.056	.050	.050	.049
AH	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AI	0.140	0.160		0.145	0.149	0.148	0.150	0.147
AJ	2.518	2.538		2.525	2.524	2.521	2.523	2.526
AK	0.040	0.060		.052	.052	.053	.053	.053
AL	0.010	0.020		.013	.013	.013	.013	.013
AM	0.140	0.160		0.152	0.152	0.153	0.153	0.153
AN	0.350	0.450		0.377	0.388	0.377	0.377	0.377
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.150	0.150	0.150	0.155	0.154
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.260	0.260	0.260	0.260	0.260
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.129
AV								
AW								
Accept/Reject								

Measured by:	H.A	Date:	08/08/16
Audited by:	SJ	Date:	08/08/16
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40753
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				.16	.17	.18	.19	.20
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.154	0.153	0.153	0.153	0.153
AD	3.510	3.530		3.518	3.518	3.518	3.517	3.517
AE	1.633	1.673		1.654	1.654	1.654	1.654	1.654
AF	1.493	1.513		1.504	1.504	1.504	1.500	1.505
AG	0.040	0.060		.049	.050	.050	.050	.050
AH	0.188	0.193		0.189	0.189	0.189	0.188	0.188
AI	0.140	0.160		0.149	0.150	0.150	0.150	0.150
AJ	2.518	2.538		2.526	2.525	2.525	2.520	2.520
AK	0.040	0.060		.053	.052	.052	.050	.050
AL	0.010	0.020		.013	.013	.013	.015	.015
AM	0.140	0.160		0.153	0.152	0.152	0.150	0.150
AN	0.350	0.450		0.377	0.377	0.377	0.376	0.376
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.153	0.155	0.155	0.155	0.155
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.260	0.260	0.260	0.260	0.260
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.129	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: H.A / AF Date: 08/08/17/08/08/19

Audited by: S.M Date: 08/08/15

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	S.M

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40753
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.153	.160	.160	.160	.160
AD	3.510	3.530		3.528	3.528	3.528	3.528	3.530
AE	1.633	1.673		1.653	1.653	1.653	1.653	1.653
AF	1.493	1.513		1.495	1.500	1.500	1.500	1.500
AG	0.040	0.060		.050	.050	.050	.050	.060
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.147	.150	.150	.150	.150
AJ	2.518	2.538		2.522	2.522	2.522	2.522	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.015	.015	.015	.015	.015
AM	0.140	0.160		.149	.150	.147	.147	.147
AN	0.350	0.450		.388	.388	.388	.388	.388
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.169	.169	.167	.167	.167
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.261	.261	.261	.261	.261
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: SF Date: 08/08/20

Audited by: SD Date: 08/08/20

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM <u>SF</u>	<u>JL</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40753
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

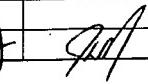
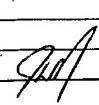
First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	217	818	119	520
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.159	0.159	0.159	0.159	0.159
AD	3.510	3.530		3.519	3.520	3.521	3.526	3.527
AE	1.633	1.673		1.653	1.654	1.654	1.657	1.657
AF	1.493	1.513		1.499	1.496	1.497	1.501	1.499
AG	0.040	0.060		0.050	0.048	0.045	0.051	0.046
AH	0.188	0.193		0.188	0.189	0.189	0.189	0.189
AI	0.140	0.160		0.147	0.147	0.148	0.149	0.149
AJ	2.518	2.538		2.525	2.525	2.524	2.523	2.525
AK	0.040	0.060		0.052	0.051	0.051	0.049	0.053
AL	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AM	0.140	0.160		0.150	0.149	0.149	0.150	0.149
AN	0.350	0.450		0.387	0.387	0.380	0.381	0.386
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.153	0.158	0.157	0.155	0.158
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.261	0.261	0.261	0.260	0.260
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: H.A Date: 08/08/21

Audited by:  Date: 08/08/21

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM 	

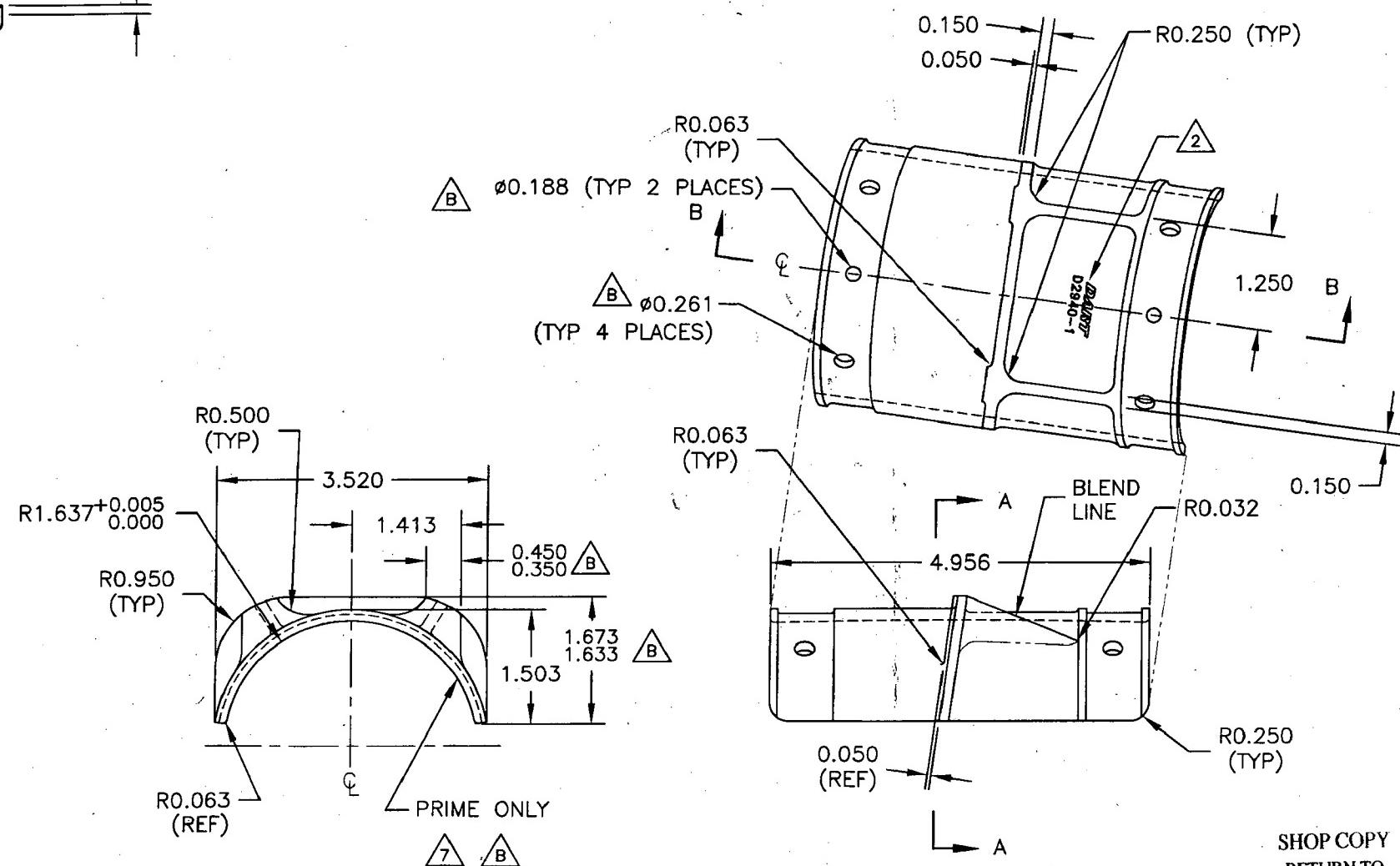
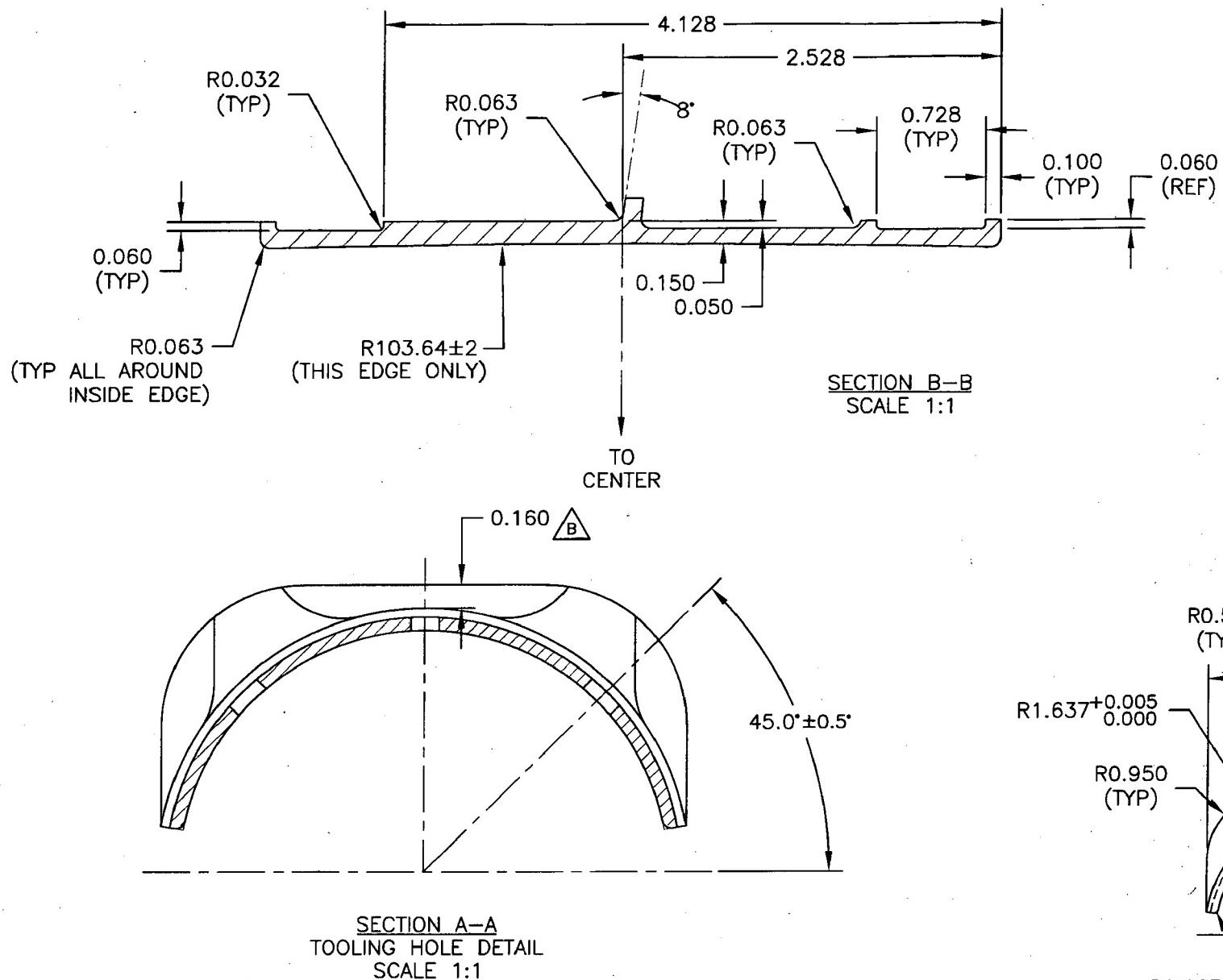
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
67.4.24 (P)
PER ECN 829



D2940-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

COPYRIGHT © 2001 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	DRAWN BY	DART
CHECKED	APPROVED	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DATE		REV. B SHEET 1 OF 1 SCALE
07.03.16		03.250 SUPPORT 1:2

